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Date: Thursday, 19/03/2009 11:02:45 AM
User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 206L/L3/L4/407 LOW, 407 HIGH GEAR SKID
Job Number : 46575	
Estimate Number : 10549	
P.O. Number :	Part Number : D206642311
This Issue : 19/03/2009 S.O. No. :	Drawing Number : N/A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SKIDTUBES	Drawing Revision : L
Previous Run : 36135	Material :
Written By :	Due Date : 15/04/2009 Qty: 1 Um: Each
Checked & Approved By : <u>JUD 09.03.19</u>	
Comment : Est Rev:J 05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM/EC Est Rev:K 07-12-04 ECN 1080p DD verified by:ec Est Rev:L 08-09-29 as per DSI9421 DD verified by:ec Est Rev:M 09-03-02 as per DSI9440 rev.a DD verified by: Est Rev:N 09-03-03 as per DSI9421 rev.b DD verified by:	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL
Comment: DOCUMENT CONTROL Photocopy bluefile and create labels per PPP D206-642-311 CHG006 <u>8 09/04/16</u>		
2.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Pick Packing Kit		
3.0	46575A	206 L HIGH GEAR SKIDTUBE
Comment: Sub-Component 206L/407 LOW, 407 HIGH GEAR SKIDTUBE 1 x D206-642-341 Batch <u>46575A</u> <u>8 09/04/16</u>		
4.0	D206648013	GHW Modification
Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s) GHW Modification batch: <u>43410</u> <u>8 09/04/16</u>		
5.0	AN4C5A	BOLT
Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s) BOLT batch: <u>M104936</u> <u>8 09/04/16</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 46575

Part Number: D206642311

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

AN960C416

washer



5

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

washer

batch:

M100993

7.0

D34131

Ring



5

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Ring

batch:

33949

8.0

D2652

Bushing



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

BUSHING

Pick:

Qty Part Number Description Batch

16 D2652 Bushing

1 D206-642-341(REF)

45318

9.0

D2712

Set Screw



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

SET SCREW

Pick:

Qty Part Number Description Batch

10 D2712 Set Screw

43810

10.0

D29321

Saddle LH Out, 206



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

SADDLE

Pick:

Qty Part Number Description Batch

1 D2932-1 Saddle

345262

11.0

D29331

Saddle LH In, 206



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

SADDLE

Pick:

Qty Part Number Description Batch

42978

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Job Number: 46575

Part Number: D206642311

Job Number:



Seq. #:

Machine Or Operation:

Description :

1 D2933-1 Saddle

12.0

D2934

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

SADDLE SPACER

Pick:

Qty Part Number Description
2 D2934 Saddle Spacer

Batch

44296

SS 09/04/16 (X)

13.0

D2935

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

SADDLE SPACER

Pick:

Qty Part Number Description
2 D2935 Saddle Spacer

Batch

44553

SS 09/04/16 (X)

14.0

D29381

Saddle LH Out, 206



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

SADDLE

Pick:

Qty Part Number Description
1 D2938-1 Saddle

Batch

44554

SS 09/04/16 (X)

15.0

D29391

Saddle LH In, 206



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

SADDLE

Pick:

Qty Part Number Description
1 D2939-1 Saddle

Batch

43188

SS 09/04/16 (X)

16.0

D3407043

Tow Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Tow Ring

batch:

43308

SS 09/04/16 (X)

W/O:		WORK ORDER CHANGES					
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Part Number: D206642311

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

D34561

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

S

Washer

batch: 43002

SS 09/04/16 (X)

18.0

D34571

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

S

Washer

batch: 44603

SS 09/04/16 (X)

19.0

MS210434

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

S

Nut

batch: M11177

SS 09/04/16 (X)

20.0

AN341A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

S

BOLT

Pick:

Qty Part Number

Description

Batch

8 AN3-41A

Bolt

M111163

SS 09/04/16 (X)

21.0

AN46A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

S

BOLT

Pick:

Qty Part Number

Description

Batch

12 AN4-6A

Bolt

M110399

SS 09/04/16 (X)

22.0

AN510A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

S

BOLT

Pick:

Qty Part Number

Description

Batch

M110363

SS 09/04/16 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Part Number: D206642311

Job Number:



Seq. #:

Machine Or Operation:

Description :

4 AN5-10A Bolt
(or AN5-11A)

Choice of bolt will depend on crosstube

23.0

AN511A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

BOLT

Pick:

Qty Part Number Description Batch

4 AN5-11A Bolt
(or AN5-12A)

Choice of bolt will depend on crosstube

M110363

SS 09/04/16 (X)

24.0

AN960JD10

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

WASHER

Pick:

Qty Part Number Description Batch

8 AN960JD10

Washer

M110985

SS 09/04/16 (X)

25.0

AN960JD416

Washer



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

WASHER

Pick:

Qty Part Number Description Batch

24 AN960JD416

Washer

M110363

SS 09/04/16 (X)

26.0

AN960JD516

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

WASHER

Pick:

Qty Part Number Description Batch

8 AN960JD516

Washer

M110523

SS 09/04/16 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

MS21042L3

Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

NUT

Pick:

Qty Part Number

Description

Batch

8 MS21042L3

Nut

M110399

88 09/04/16 (X)

28.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

NUT

Pick:

Qty Part Number

Description

Batch

13 MS21042L4

Nut

M109282

88 09/04/16 (X)

29.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT KITS 100% FOR COMPLETENESS

88 09/04/16 (X)

30.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-642-311

Location: 85

PPP Rev: 9/4/16

9/4/16

(10)

SEP

31.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/27

Job Completion



mf 09-04-24

46575A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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